



Dart Aerospace Ltd.
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Hawkesbury, ON
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Tel (613) 632-5200

D4273-042
Job Sheet 171882



Part No: D4273-042

Job Qty: 1 ea

Part Name: Basket Base Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/15/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 6,7,8,9,10 IPP Rev:A 10.11.16 new issue DD
verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD
verf:EC IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/13/18	0.00	0.00	Start Up Large Fab-6		0.17.18-3-13
100	Large Fab	1 pcs		2/14/18	0.00	31.15	Large Fab 1		2/18-3-13
110	QC	1 pcs		2/14/18	0.00	0.00	QC9		10 18-3-15
120	QC	1 pcs		2/14/18	0.00	0.00	QC5		10 18-3-15
125	HandFinish	1 pcs		2/14/18	0.00	0.40	HandFinish2		DR 18-3-19
130	Powdercoat	1 pcs		2/15/18	0.00	0.67	Powdercoat2		BR 18-3-19
140	QC	1 pcs		2/15/18	0.00	0.00	QC3		10 18-3-20
150	Packaging	1 pcs		2/15/18	0.00	0.00	Packaging3-2		10 18-3-20
160	QC21-SA	1 Ea		2/15/18	0.00	0.00	QC21		21 MAR 20 2018

Part Op 100 - 1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED Descriptions: TO WELDED AFTHER MESH IS INSTALL) weld as per dwg D4273 using DT10317 2- Cut D4279-1 (MADE ON THIS W/O) base mesh and tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends (D4279-5/-9)

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

M138760 START 18:45 - 01:375° FINISH 24:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5036087
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5047257
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5034377
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5041495
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5047279
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5044540(2)
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	50360180
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5037801
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5039317
D4277-19	Rib	1 Ea (1 ea)	90-Start up Operation	5015631
D4277-3	Rib	1 Ea (1 ea)	90-Start up Operation	5015591
D4277-5	Rib	2 Ea (2 ea)	90-Start up Operation	5015962
D4277-9	Rib	1 Ea (1 ea)	90-Start up Operation	5015811
D4278-041	Upper Rib Assembly-Hoop	1 Ea (1 ea)	90-Start up Operation	5017978
D4278-045	Rib Assembly, Fwd Cham	2 Ea (2 ea)	90-Start up Operation	5045252
D4278-047	Upper Rib Assembly-Straight	1 Ea (1 ea)	90-Start up Operation	5017734
D4279-5	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation	5005862
D4279-7	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5172970
D4279-9	End Mesh, Basket	1 Ea (1 ea)	90-Start up Operation	5024968
D4306-044	Rib Assembly, RH	1 Ea (1 ea)	90-Start up Operation	5031398
D4306-045	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5037167
D4306-1	Rib	1 Ea (1 ea)	90-Start up Operation	5044670
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5036909
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	90-Start up Operation	5041893

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	68	0
	D3913-1	1	6	0
	D3913-15	1	21	0
	D3913-3	1	9	0
	D3913-9	1	8	0
	* D3916-5 missing tx	3	26	0
	D4016-1	3	83	0
	D4017-7	3	69	0
	D4021-1	3	60	0
	D4277-19	1	3	0
	D4277-3	1	4	0
	D4277-5	2	12	0
	D4277-9	1	2	0
	D4278-041	1	6	0
	D4278-045	2	4	0
	D4278-047	1	5	0
	D4279-5	1	6	0
	D4279-7	2	1	0
	D4279-9	1	6	0
	D4306-044	1	9	0
	D4306-045	1	7	0
	D4306-1	1	4	0
	D4672-1	2	52	0
	M304EX0.75-16F	32	459	0

Part Specifications

Specifications could not be found.

Plex 2/8/18 3:54 PM Dart.Gagnon.Michelle



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Container No: S050976



Part: D4273-042

Job No: 171882

Serial No/Batch: S050976

Revision:

Inspector:

Date: 03/13/18

Master Unit 001312



Job No 171882